

23/05 SPLIT

Dart Aerospace Ltd.

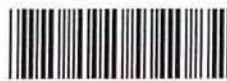
Date: Friday, 16/05/2008 7:50:14 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE			
Job Number	: 39313		Part Number	: D33193			
Estimate Number	: 10606		Drawing Number	: D3319 REV. B			
P.O. Number	:		Project Number	: N/A			
This Issue	: 16/05/2008	S.O. No. :	Drawing Revision	: B			
Prsht Rev.	: NC		Material	:			
First Issue	: / /		Due Date	: 23/05/2008			
Previous Run	: 38091		Qty:	: 12 Um: Each			
Written By	:						
Checked & Approved By	:						
Comment	: Est: A 05/05/12 New issue KJ/JLM Est Rev:B Now on Waterjet 06-10-03 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048 50:
		Comment: Qty.: 3.4150 sf(s)/Unit Total: 40.9802 sf(s) 1010/1025/A21/6aA SHEET .048" Thick Batch: 1060603 8-5-20
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: Prog Rev: 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPLATE
Job Number: 39313		Part Number: D33193
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE Form using DT8326 & DT8261 as per Dwg D3319 Rev: <u>6</u>		<u>50 05/29/21</u> 
7.0	QC6	DIMENSIONAL CHECK 
Comment: DIMENSIONAL CHECK		<u>5 08/05/29 46</u> 
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: _____ Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod <u>M106762</u>		<u>08-05-29. 8P</u> 
9.0	QC10	VISUAL INSPECTION OF GROUND WELDS 
Comment: VISUAL INSPECTION OF GROUND WELDS		<u>5 08/05/29 08</u> 
10.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<u>6 08/05/29 08</u> 
11.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: <u>10:10</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>10:40</u>		<u>m 105642</u> 
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		<u>BK 08-05-29</u> 
13.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.		<u>8/5/29</u> 

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39313

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 49b

85/29

SP (85)

14.0

QC21

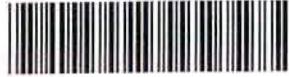
FINAL INSPECTION/W/O RELEASE



08/05/2008

Comment: FINAL INSPECTION/W/O RELEASE

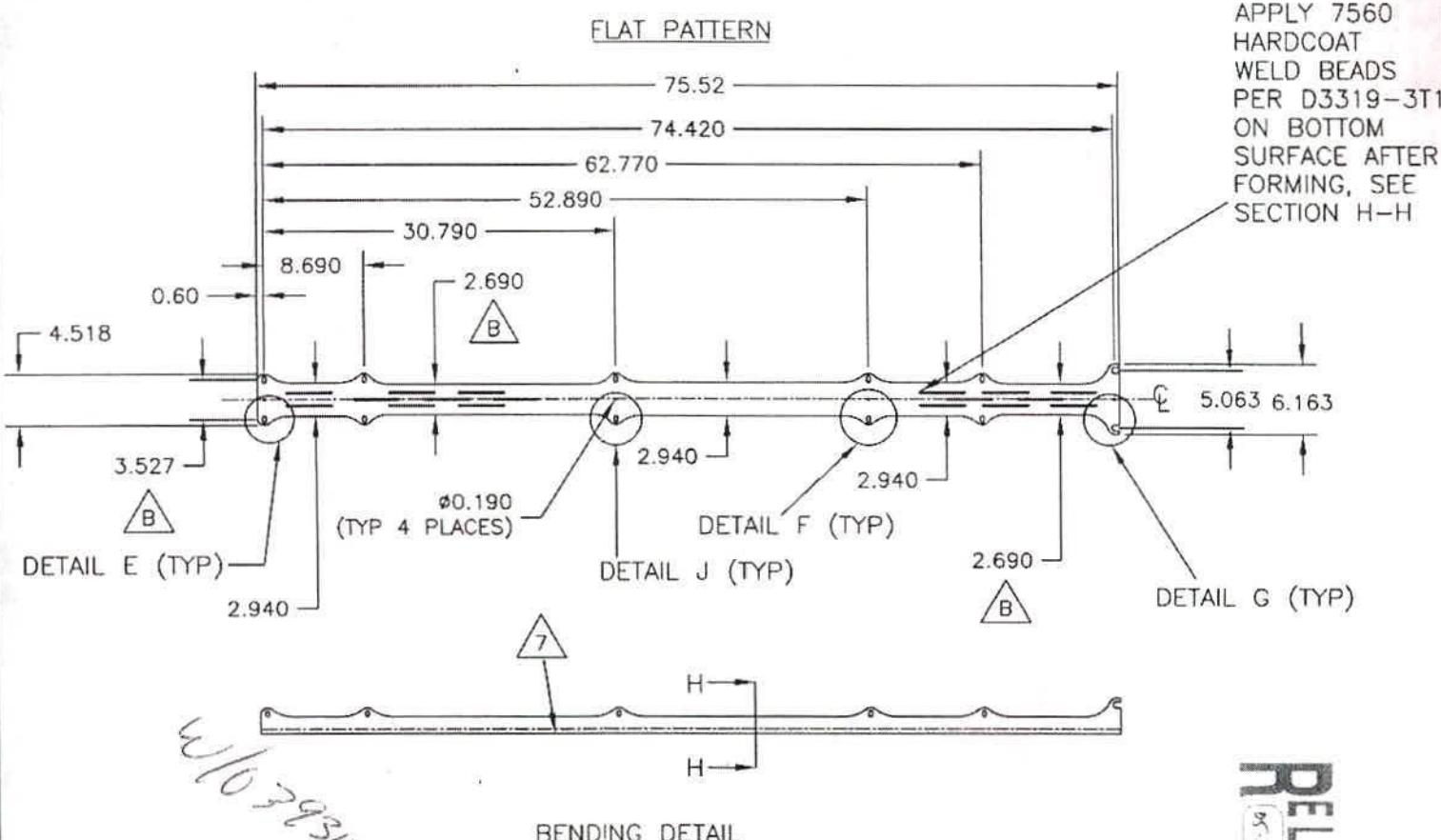
Job Completion



MF 08-05-29

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	REV. B SHEET 2 OF 5 SCALE 1:15



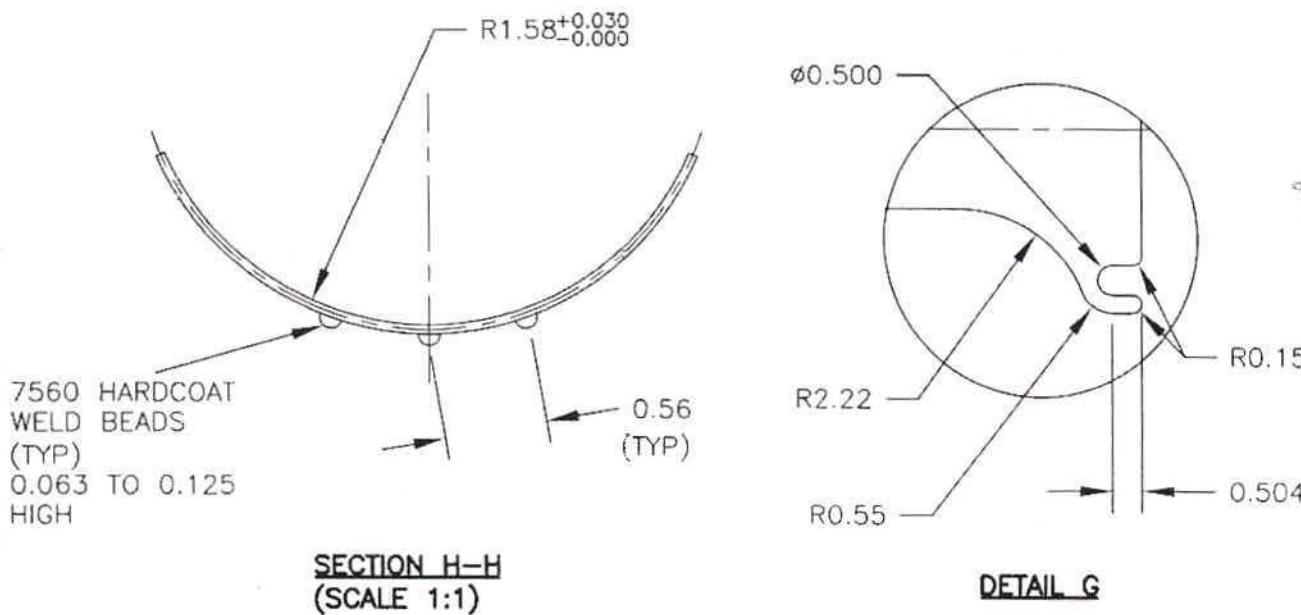
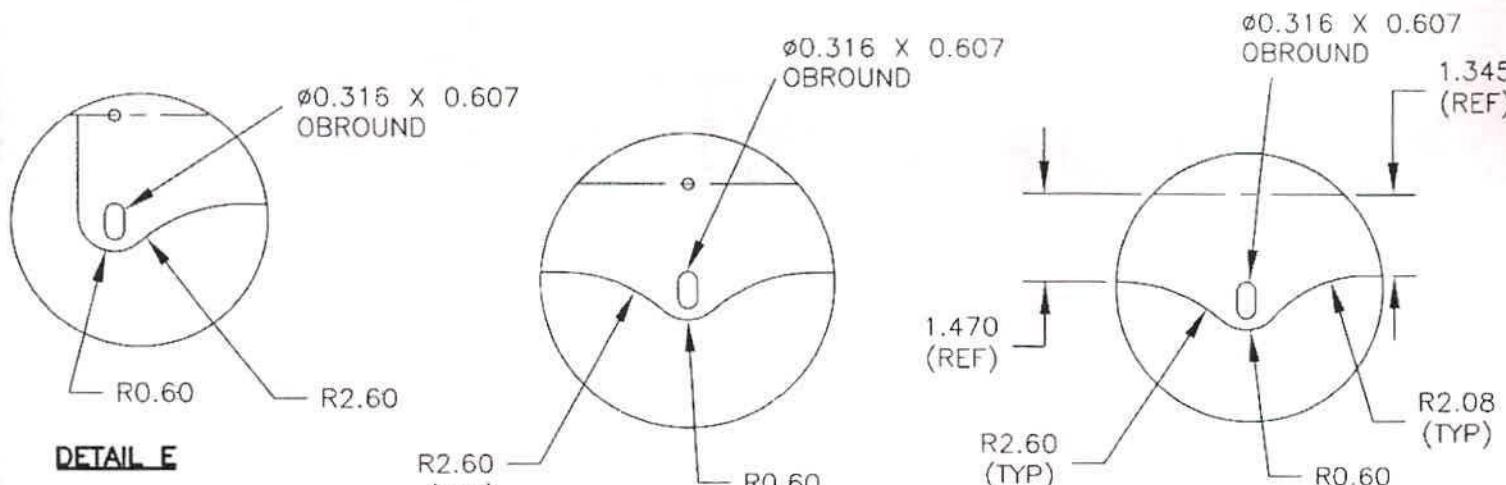
RELEASED

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN <i>PH</i>	DRAWN BY <i>JH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D 3319	REV. B	SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE	SCALE 1:3		

RELEASED

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DATA AEROSPACE LTD

Work Order: 39313

Description: WEAR PLATE

Part Number: D3319-3

Inspection Dwg: 1339-3 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi .190$	$+.005 -.001$.190	X			
$\phi .316$	$+.006 -.001$.316	X			
.607	$+.008 -.001$.608	X			
$\phi \cancel{.518}$	$+.001 -.001$					
$\phi .316$	$+.006 -.001$.317	X			
.518	+.008 -.001					
3.527	$+. -.010$	3.526	X			
4.518	$+. -.010$	4.516	X			
2.940	$+. -.010$	2.949	X			
2.690	$+. -.010$	2.696	X			
5.063	$+. -.010$	5.063	X			
6.163	$+. -.010$	6.165	X			
.60	$+.030$.595	X			
8.690	$+. -.010$	8.690	X			
30.790	$+. -.010$	30.790	X			
52.890	$+. -.010$	52.890	X			
65.770	$+. -.010$	65.770	X			
74.420	$+. -.010$	74.420	X			
75.55	$+.030$	75.55	X			

Measured by

12

Audited by:

Prototype Approval:

一

100

13

Date

Date: _____

10

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	